

Work Order ID 67208

Thursday, March 10, 2011 12:31:05 PM

Page 1

Item ID: D2565-211

Accept

Setup Start

Revision ID:

Stop

Item Name: Strut

Start Date: 3/10/2011 Start Qty: 5.00

Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch as per Dwg D2565 using DT 8313

SB 11/03/14

(S)

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr and polish

SB 11/03/14 (S)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

SB 11/03/14

(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



M 115951.

5 BK 11-3-28.

Powdercoat

Memo

0.00

Powder Coating

START TIME: 12:50 OVEN TEMPERATURE:
700° FINISH TIME: 1:20

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M-L 11/03/28



150

Identify as per dwg & Stock Location: 253

0.00



Packaging

Memo

0.00

Packaging

11/3/30 50 SP

W/O:		WORK ORDER CHANGES					
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Item ID: D2565-211

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 3/10/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/30

CMF

11-03-30

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Picklist Print

Thursday, March 10, 2011 12:31:11 PM

Page 1

Work Order ID: 67208

Parent Item: D2565-211

Parent Item Name: Strut



Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: D□01.08.28□Added Powder coat, and added Inspection level 3 and 21.□SM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

100

f

265.2314

1.2

6.315789



304 RD Tube .750 x .049W



JB 11/03/14

Location

Loc Qty

Loc Code

MAT

259.61138

108498

0

110113

0

115010

12.264255

116720

3.347125

117030

244

10

MAT014

0.00003

115990

0.00003

MAT017

5.62

109314

4.33

110113

1.29

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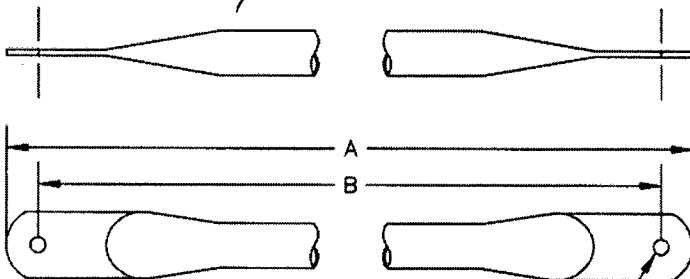
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

O. 67208

2/11-03-10



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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